



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

02020

D350-636-011GB
Job Sheet 173783



Part No: D350-636-011GB

Job Qty: 1 ea

Part Name: Skidtube LH Aerazur / Apical Cylindrical Compat. - Glossy Black



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 RevF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP Rev:P 10.06.22 revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/28/18	0.00	0.00	Start Up Skidtubes-1		
200	SprayPaint	1 pcs		3/28/18	0.00	0.56	Spray Paint		AS MAR 25 2018
210	QC	1 pcs		3/28/18	0.00	0.00	QC14		18-3-27
230	HandFinish	1 pcs		3/29/18	0.00	0.67	HandFinish4		16-31-3
240	QC	1 pcs		3/29/18	0.00	0.00	QC5		38
250	Packaging	1 pcs		3/29/18	0.00	0.00	Packaging1-3		7.10.
260	QC	1 pcs		3/29/18	0.00	0.00	QC4		7.10.
265	DC	1 pcs		3/29/18	0.00	0.00	DC	DAS 21	7.10.
270	Packaging	1 pcs		3/29/18	0.00	0.00	Packaging3-1	21	7.10.
280	QC21-FG	1 Ea		3/29/18	0.00	0.00	QC21	9-20	MAR 29 2018

Part Op 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 138747 2-
Descriptions: PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 138823

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: EXP DATE: 4-

Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5- Coat all exposed fasteners with "LPS Procyon" batch:

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S055112



Part: D350-636-011GB

Job No: 173783

Serial No/Batch: S055112

Revision:

Inspector:

S055112LH

10:19 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-636-011	Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.	1 Ea (1 ea)	90-Start up Operation	001990
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5048375
AN3C5A	Bolt (x16) 5019396	34 Ea (34 ea)	230-HandFinish	5055231
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5019397
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	FM137055
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	FM1137203
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5053257
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	5048732
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5054681
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5054875
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5047122
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5047737
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5037408
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5048060
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5049290
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5047586
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5041206
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5046363
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5046244
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5053037
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5034401
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5044236
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409-121
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5036714
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5049976
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	M138441722
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	FM137162
D2741GB	Replacement Blade -Gloss Black	1 Ea (1 ea)	250-Packaging	5054783
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5052854
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5040493
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5016888
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	FM125635

x22

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-636-011	1	4	0
	ALS4-1032-225	38	1,379	0
	AN3C5A	34	459	0
230-HandFinish	AN3C6A	4	158	0
	AN6C44A	4	435	0
	AN8C35A	1	70	0
	D2745	8	81	0
	D3488-041	1	13	0
	D3492-1	8	167	0
	D3492-3	8	120	0
	D3535-25	1	27	0
	D3536-25	1	40	0
	D3537-1	3	119	0
	D3631-1	8	115	0
	D3791-1	1	8	0
	D3793-1	1	26	0
	D3793-3	1	34	0
	D3794-1	1	22	0
	D3794-3	1	50	0
	MS21043-6	4	141	0
	MS21083C8	1	84	0
	NAS1149C0332R	38	3,808	0
	NAS1149C0832R	1	95	0
	NAS1515H3L	4	283	0
	NAS1611-010	8	245	0
	NAS1611-013	8	335	0
	AN8C21A	2	156	0
250-Packaging	D2741GB	1	0	0
	D3493-1	2	34	0
	D3532-1	2	50	0
	MS21083C8	2	84	0
	NAS1149D0863J	2	161	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					